Work Order ID 115094

Monday, March 17, 2014 2:43:02 PM

115094

Item ID: D2565-111 D2565-111
Revision ID:
Item Name: Strut B115094

Start Date: 3/17/14 **Start Qty:** 6.00 *6*
Required Date: 3/17/14 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MCJ **Date:** 14-03-19
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Draw Nbr	Revision Nbr
D2565	Rev E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC Brake NC	Punch ends and deburr as per dwg NC BRAKE **Memo** Punch as per Dwg D2565 using DT 8313	0.00 0.00				6			FF 14-03-25
110 *110* Small Fab Small Fab	Small Fab **Memo** Deburr	0.00 0.00				6			FF 14-03-25
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				6			

DAS 27 9-89

14/3/25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115094

Monday, March 17, 2014 2:43:02 PM

1150940

Item ID: D2565-111
Revision ID:
Item Name: Strut
Start Date: 3/17/14 **Start Qty:** 6.00 *6*
Required Date: 3/17/14 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M128004 **Memo** START TIME: 2:18 OVEN TEMPERATURE: 400° FINISH TIME: 2:45	0.00 0.00				6	0	H-331	DAS 27 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				6			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 57252 **Memo**	0.00 0.00				Ox		14-4-1	DAS 26 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
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Approvals: **Process Plan:** _____ **Date:** _____
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00				MCJ		14-04-01	
160									
QC	**Memo**	0.00							
Quality Control									

14-04-01

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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DISPOSITION

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Use-as-is ☐
Suspected Unapproved ☐

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Large Fab ☐ Composite ☐ Supplier ☐ ☐

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☐ Wrong Stock Pulled

☐ Other

Picklist Print

Monday, March 17, 2014 2:43:02 PM

Work Order ID: 115094 *115094*

Parent Item: D2565-111 *D2565-111*

Parent Item Name: Strut

Start Date: 3/17/14 **Required Date:** 3/17/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: E01.06.04Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC
IPP: E06.05.03 Change level 2/8 to QC5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	288.0867	1.1375	7.184210			

M304TR0.750W.049

304 RD Tube .750 x .049W

**

FF 14-03-25

Location	Loc Qty	Loc Code
MAT017	288.0867	
122312	10	
124768	49.27	
M126183	97.2267	
M128084	131.59	

7.1842

DQA: _____ Date: _____

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DART AEROSPACE LTD

DART AEROSP

Description: STrut Work Order: 115094

Inspection Drawing: D2565 Rev: L Part Number: D2565-111

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.65	± 0.03	13.65	✓		S Fab-07	
12.85	± 0.03	12.85	✓		S Fab-07	

Measured by:	Checked By: DAS 30 9-89	QC inspector: AS 27 9-89	Engineering Approval (*if necessa*
FF			
Date 14-03-25	Date 14/03/25	Date 14/3/25	Date